

Date: Monday, 12/12/2005 7:15:28 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT	
Job Number	: 25200		Part Number	: D31691	
Estimate Number	: 11336		Drawing Number	: D3169 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/12/2005	S.O. No.	: N/A	Drawing Revision	: A
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 12/19/2005	
Previous Run	: N/A		Qty:	10	Um: Each
Written By	<u>See comment below</u>				
Checked & Approved By	<u>See comment below</u>				
Comment	: Est Rev:A 02.10.17 New issue KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6B0625X02500	6061-T6 Bar .625" x 2.5"		
		Comment: Qty.: 0.3360 f(s)/Unit Total : 3.3600 f(s) Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8 or QQ-A-250/11) (M6061T6B0.625x02.500) Batch: M15919	Ep 05/12/15	10
2.0	BAND SAW	BAND SAW		
		Comment: BAND SAW Cut blanks: 3.850" x 2.50" x 0.625" thick	Ep 05/12/15	10
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1	Ep 05/12/15	10
		1-Machine as per Folio FA283 and Dwg D3169	Ep 05/12/15	10
		2-Deburr & Tumble	Ep 05/12/15	10
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	Ep 05/12/15	10
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK	J-L 05.12.15 10	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 05/12/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SUPPORT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 88

10 05/12/16 (10)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5/12/20 (10) 05/12/20 (10)

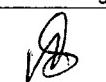
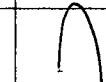
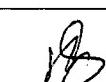
05/12/20 (10)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

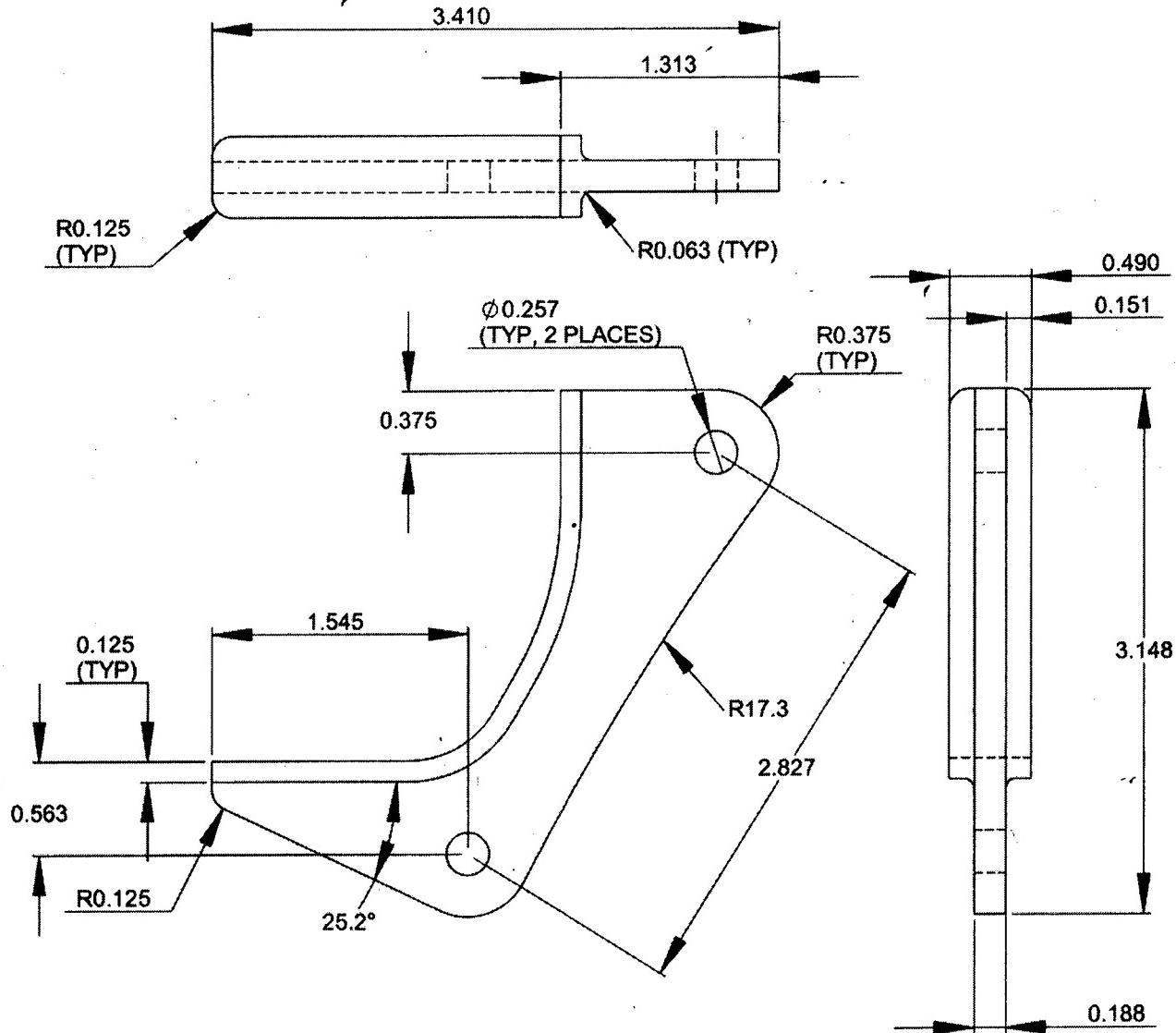
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 05/12/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/15	#3.0	one part scrap. Part was lifted in vise	 AB 05/12/15	Scrap and Destroy and Replace	EP 05/12/15	 05/12/15	 AB 05/12/15	 J 05/12/15

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3169	SHEET 1 OF 1
DATE	02.09.11	TITLE	SCALE
		SUPPORT	1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011**D3169-1 SUPPORT**

- 1) MACHINE PER DWG FILE "D3169-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11)
(REF DART SPEC M6061T6B OR M6061T6S)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Support	Part Number:	D3169-1
Inspection Dwg: D3169	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>E.P.</i>	Audited by:	<i>J.L.</i>	Prototype Approval:	N/A
Date:	<i>25/12/15</i>	Date:	<i>05.12.15</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	